

Date: Wednesday, 1/11/2006 4:29:29 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE SIDE LH (206 HI-SLOPE)
Job Number : 25471	
Estimate Number : 11000	
P.O. Number : N/A	Part Number : D26021
This Issue : 1/11/2006 S.O. No. : N/A	Drawing Number : D2602 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : 25140	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 1/30/2006 Qty: 10 Um: Each
Checked & Approved By : SEE ABOVE DATE & USER	
Comment : Est. D 04.02.25 Reformat KJ/RF Note: Issue with part number D2602-2	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 1.4146 sf(s)/Unit Total : 14.1456 sf(s)
 2024-T3 .040 sheet
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S.040) Batch H19059

ml 06/02/20 10

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut Blank per template DT8243

ml 06/02/20 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA145 and Dwg D2602
 Stack of 10
 Identify as D2602-1

ml 06/02/20 10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/02/20 10

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ml 06/02/20 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Q Date: 06/02/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:29:30 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 25471

Part Number: D26021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2602

DL 06/02/22 10
SB 06/02/24 10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-02-24 10

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD 06/02/26 10

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-02-27 10

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: —

use for 25446 w/o

ml 06/02/27 10

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/02/27 10

Job Completion



U 06.02.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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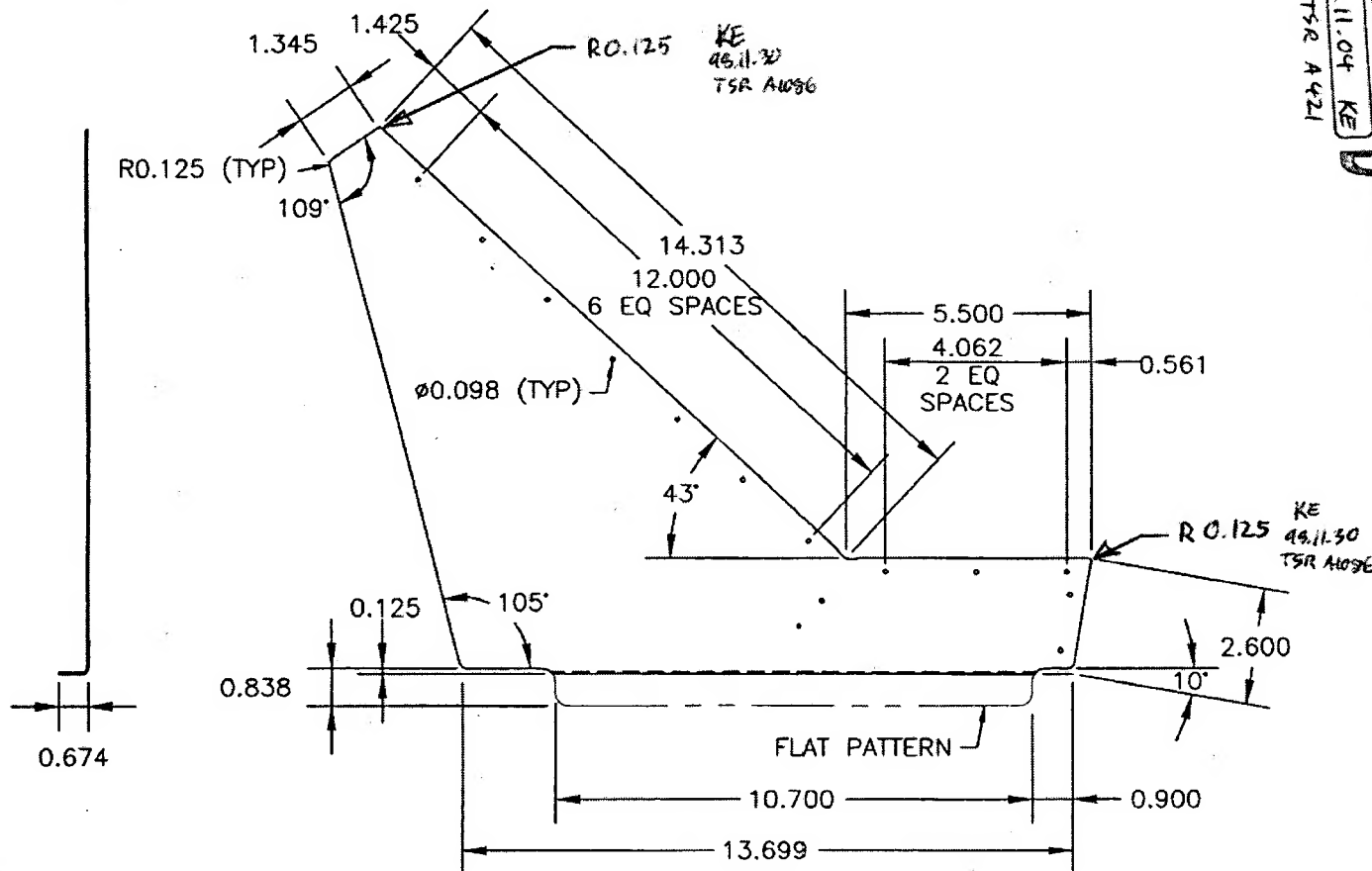
NOTE: Date & initial all entries

DAVEIT



RELEASED
97.11.04 KE
TSR A421

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	BW	VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	KE	D2602
DATE	TITLE	SHEET 1 OF 1
97.10.22	CONSOLE SIDE	SCALE 1:4
A	97.10.22	D2602 WAS D206-547-21/ -22
AI	02.06.04	ADD FINISH



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
 PROFILE CONTROLLED BY FOLIO H2602
 BEND RADIUS 0.093
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 **AI**
 D2602-1 SHOWN
 D2602-2 OPPOSITE

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

Measured by: <i>gml</i>	Audited by: <i>En</i>	Prototype Approval:
Date: <i>06/02/20</i>	Date: <i>06/02/20</i>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	